

Date: Friday, 15/02/2008 11:49:27 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BOLT
Job Number	: 37478		
Estimate Number	: 10372		
P.O. Number	:	Part Number	: D312121
This Issue	: 15/02/2008 S.O. No. :	Drawing Number	: D3121 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 36668	Material	:
Written By	: <u>15/02/08</u>	Due Date	: 22/02/2008 Qty: 60 Um: Each
Checked & Approved By	:		
Comment	: Est. A04.02.09 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303H0500	303 HEX BAR
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(60)

Comment: Qty.: 0.0417 f(s)/Unit Total: 2.5020 f(s)

303 HEX BAR

Material: AISI 303 SS 1/2" Hex Bar
(M303H0.500)

Batch: M106789

N.A

08/02/17

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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(60)

Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-21

2-Identify as D3121-21

3-Deburr break all sharp edges 0.005" to 0.010"

N.A 08/02/17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(60)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 08/02/17

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

N.A 08/02/18 60

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 66

N.A 08/02/19 (X60)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BOLT

Job Number: 37478

Part Number: D312121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/03

Job Completion



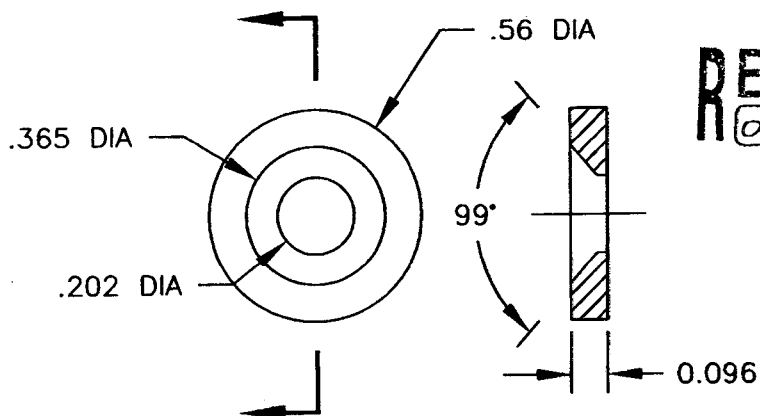
mi 2008/2/19

60

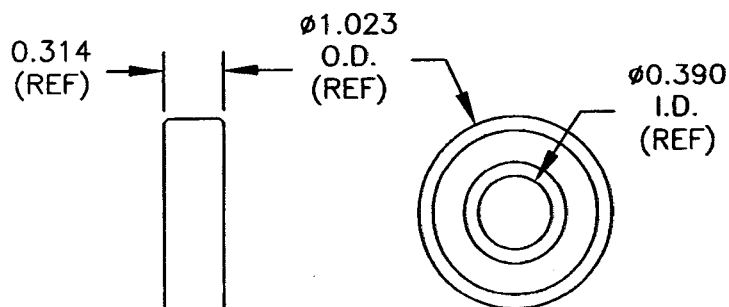
h

DART

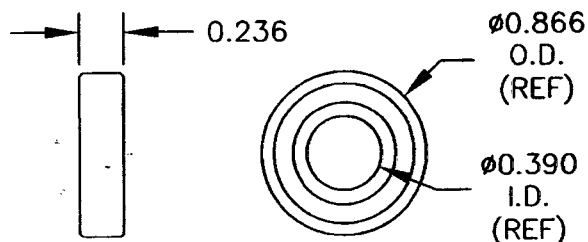
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

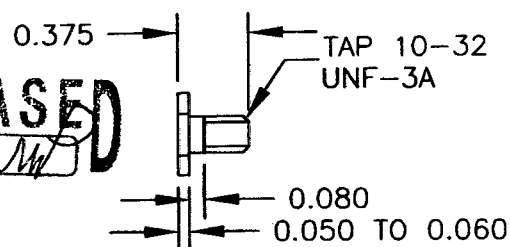
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

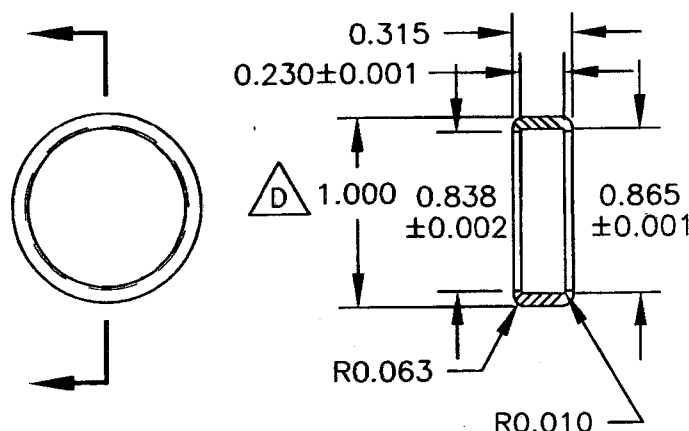
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

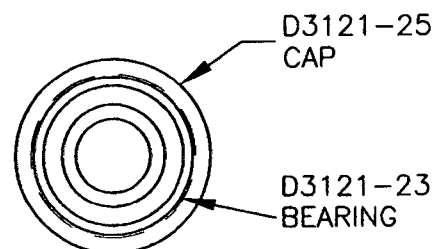
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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